

Date: 1/4/2007 8:23:15 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 30167		
Estimate Number	: 12626		
P.O. Number	: N/A	Part Number	: D2127251105
This Issue	: 1/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D212-725-1 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A
	Type: MACHINED PARTS	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 1/11/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	15 Um: Each
Comment	: Est Rev:A New Issue 07-01-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0 M304R1600 1250



B6 07-01-04

Comment: Qty.: 0.0368 f(s)/Unit Total: 0.5513 f(s)
 304SS 1.500" ROUND BAR
 Batch: 101549

2.0 HARDINGE

HARDINGE CNC LATHE SMALL



B6 07-01-04

Comment: HARDINGE CNC LATHE SMALL
 1-TURN AS PER FOLIO FA660& DWG D212-725-1,
 FOLIO REV: N/A
 DWG REV: A

2-DEBURR AS REQUIRED

B6 07-01-04

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B6 07-01-04

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

[Signature]
 07-01-05

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

[Signature] 07-01-09

(15)

package for each

Date: Thursday, 1/4/2007 8:23:15 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 30167

Part Number: D2127251105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTIONW/O RELEASE



(5)

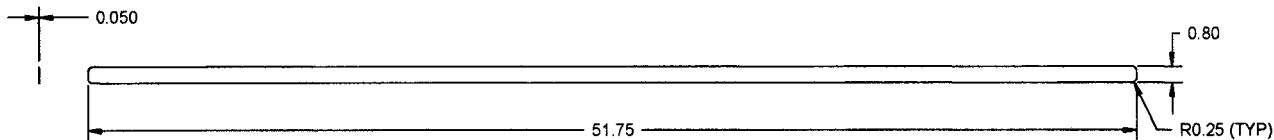
Comment: FINAL INSPECTIONW/O RELEASE

870109

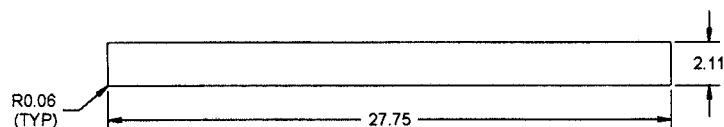
Job Completion



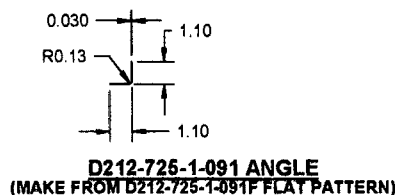
u 870109



D212-725-1-089 STRAP



D212-725-1-091F FLAT PATTERN



D212-725-1-091 ANGLE
(MAKE FROM D212-725-1-091F FLAT PATTERN)

D212-725-1-089 NOTES:

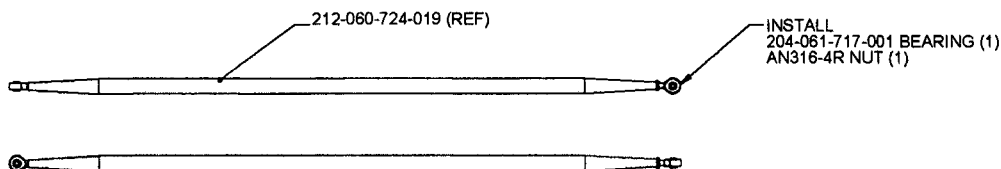
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.050 (18 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S18GA)

D212-725-1-091 NOTES:

2) MATERIAL: AISI 304/316 STAINLESS STEEL 0.030 (22 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S22GA)

GENERAL NOTES:

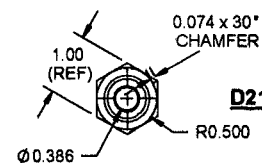
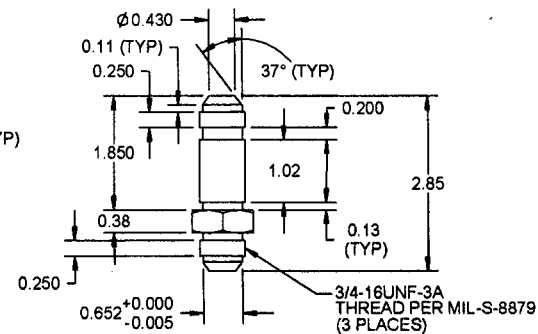
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



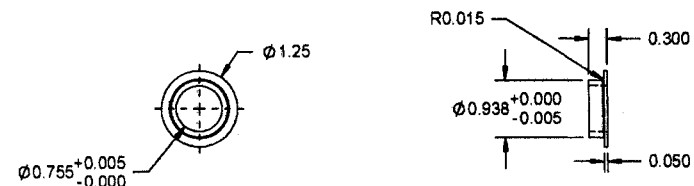
D212-725-1-921 ROD ASSEMBLY
(MADE FROM 212-060-724-019)

D212-725-1-921 NOTES:

- 1) MATERIAL: MADE FROM 212-060-724-019 TUBE ASSEMBLY
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



D212-725-1-093 UNION
(SCALE 1:3)



D212-725-1-105 BUSHING
(SCALE 1:3)

D212-725-1-105 BUSHING:

1) MATERIAL: AISI 303/304/316 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R)

D212-725-1-093 UNION:

2) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR (REF. DART SPEC. M303H)

GENERAL NOTES:

- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

REFERENCE ONLY

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 33 OF 37
DATE 06.12.08		TITLE 212S DETAIL PARTS	SCALE 1:8
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